

Date: Tuesday, 11/13/2007 1:26:45 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CAP
Job Number : 35663	
Estimate Number : 10519	
P.O. Number :	Part Number : D2855
This Issue : 11/13/2007 S.O. No. :	Drawing Number : D2855 REV. A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : 34998	Material :
Written By :	Due Date : 12/20/2007 Qty: 40 Um: Each
Checked & Approved By : <u>11/13</u>	
Comment : Est: B 00.06.22 Added receiving step & removed P/O for powder coat EC	

## Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING  
Issue P/O: 5037  
Cast per Dwg D2855  
Material Release Note Required

11/13/14 (40)

2.0	D2855P	Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)  
CAP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
Recieve & Inspect for Transit Damage  
Ensure Material Release Note is attached

7/12/12 50 (40x)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

11/13 (40) conts

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
1- Drill as per Dwg D2855 using DT8235  
2- Open holes to 19/64"  
3- Deburr

FF 07-12-14 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAP

Job Number: 35663

Part Number: D2855

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 4/12/17 (40X)

7.0

POWDER COATING

POWDER COATING



M 105914



(40X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-1 07/12/17

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07-12-12

(40X)

9.0

ALS71032225

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 80.0000 Each(s)

INSERT

Pick:

Qty Part Number

Description

Batch

2 ALS7-1032-225

Insert

M 100489

X?

or AKS7-1032-225

or ALS4-1032-225

or AKS4-1032-225

48

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Inserts as per Dwg D2855

48 07-12-12 (40X)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

48 12/17 (40X)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-22

48 04-12-12 (40X)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAP

Job Number: 35663

Part Number: D2855

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*2007/12/18*  
*W*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

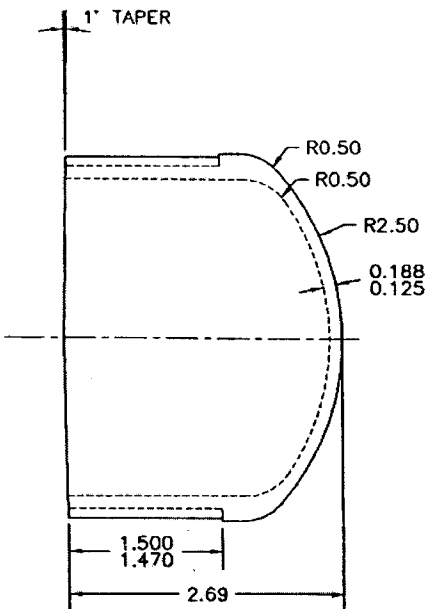
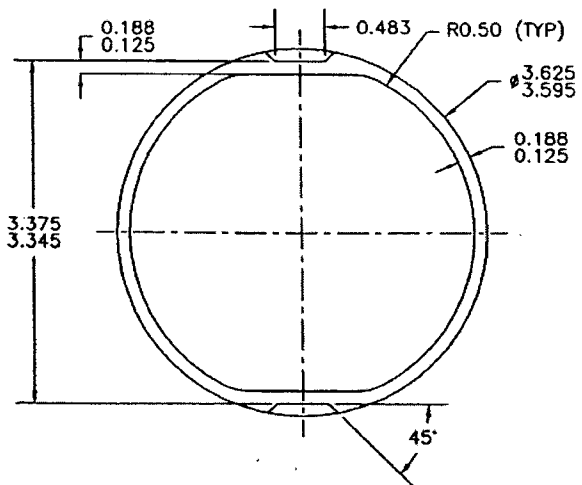
**NOTE:** Date & initial all entries



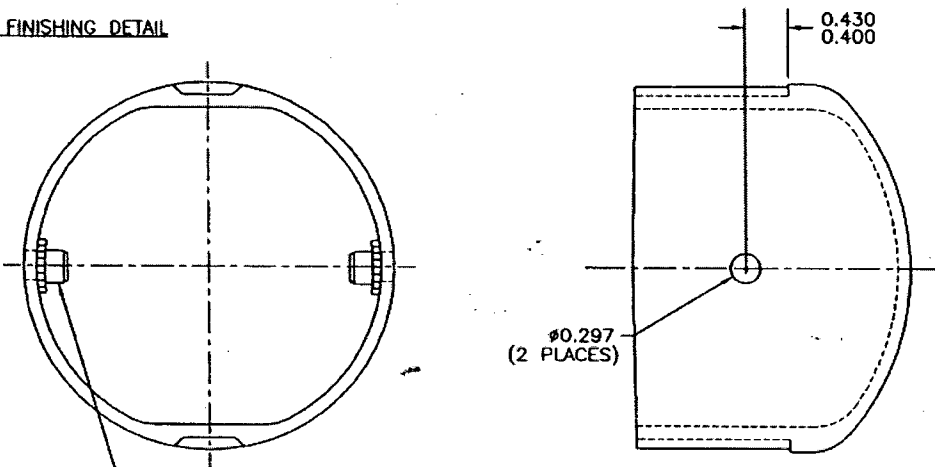
DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. A
#	#	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
<i>SP</i>	<i>KE</i>	D2855	
DATE	TITLE	SCALE	
98.12.12	CAP	NTS	
A	96.12.12	NEW ISSUE (WAS D2575 REV. E)	

RELEASED  
98.12.14 DS

D2855 CASTING DETAIL



D2855 FINISHING DETAIL



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR  
ALS7-1032-225, OR AKS4-1032-225) INSERT ON  
INSIDE OF CAP (AFTER POWDER COAT)  
(2 PLACES)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
MATERIAL: CAST ALUMINIUM ALLOY A356.2 (F)

43 KE 99.09.12

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 35663

# Aluminum Foundry Ltd

714-716 Calais  
Dorval, Québec H9P 2P3  
Tel: (514) 631-1331  
Fax: (514) 631-8448

email: info@foundryafpw.com

## Packing Slip


Packing Slip No.:

32337

Shipped Date:

Dec 10, 2007

<b>Sold to:</b>	<b>Ship to:</b>
<b>DART AEROSPACE</b> 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7  Tel. (613) 632-3336 Fax (613) 632-4443	<b>DART AEROSPACE</b> 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7
<b>Order No.:</b> 5037	
<b>Shipped By:</b> PUROLATOR	
<b>Tracking No.:</b>	

Item No.	Unit	Description	Quantity
Z098046	Each	D2855 CAP REV.A 	40
<b>Received by:</b>			
<b>Date:</b>			
<b>Comment:</b>			



CERTIFICAT DE CONFORMITÉ  
CERTIFICATE OF COMPLIANCEFONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE  
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD714-716 CALAIS, DORVAL, QC H9P-2P3  
TEL : (514) 631-1331 FAX: (514) 631-8448Expédié à  
Shipped**DART AEROSPACE**

A.F. &amp; P.W.Série no./Serial no.

**1270 Aberdeen Street**

Packing

Date: **013/12/2007** Slip No. **32337****Hawksbury, ON, K6A 1K7**Vôtre No. Commande **5037, 5113**

Your order No.

Ceci est pour certifier que le matériel liste ci-dessous est selon les spécifications du bon d'achat ci-haut, et que les documents en évidence des rapports et certificats de détaillante sont en filière dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantité Quantity	Description	Notre No. Our No.	Spécifications	Note d'autorisation Incoming Release note
70	D 2855 CAP	Z098046	A356.2	Ingot#850156
30	D 2965 CAP	Z200080	A356.2	Ingot#850156

Analyse  
Analysis (as in Ingot)

(Si)	7.00%	(Al)	balance
(Fe)	0.08%		
(Cu)	0.00%		
(Mn)	0.00%		
(Mg)	0.40%		
(Zn)	<0.01%		
(Ti)	0.18%		

Donne  
Yield :Résistance à la tension :  
Tensile Strength :Allongement par pouce carré :  
P.S.I. Elongation :

%

Pour et au nom de  
For and on behalf of :FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE  
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTDDept/Dep :  
Par/Per :

Coc-100